

Work Order ID 53086

October 22, 2009 3:52:10 PM



Page 1

Item ID: D3186-4

Accept



Setup Start



Revision ID: E

Stop



Item Name: Spacepod Door, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cast Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

53086-RP

Date:

10-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

RT 10-08-11

PTO

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subsidiary

XL

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

computer

RT 10-08-11

Dart Aerospace Ltd

W/O: 53086		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-08-10	100	Perm. Change. trim spaced door to fit spaced before drilling any holes or cutting out slots for latches Per 257008	AT	10-08-10	1			
		QC5 Siobalio (to) permanent change		10-08-11			Siobalio	

Part No: D3186-4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53086

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Page 2



Item ID: D3186-4

Accept



Setup Start



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Item Name: Spacepod Door, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/11 [Signature]
ME
10-8-11



October 22, 2009 3:52:15 PM

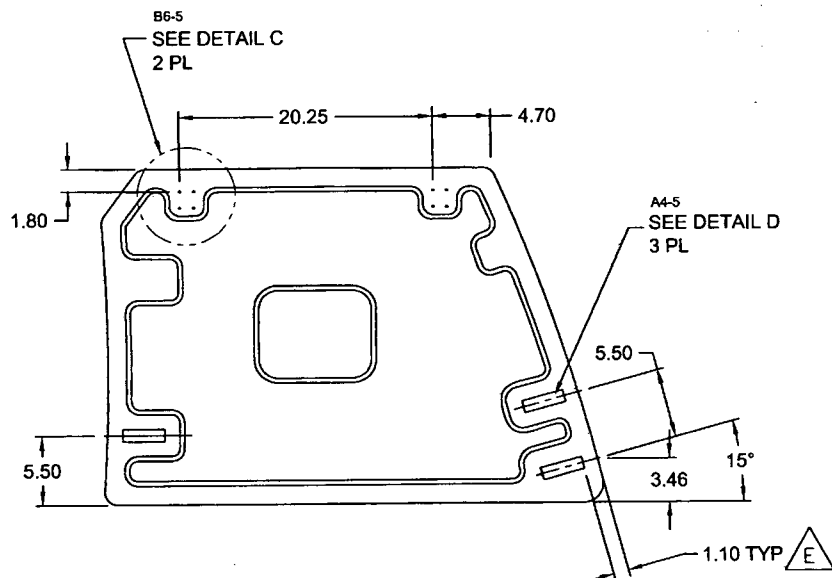
RESEARCH



Required Date: 04/11/2009

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-2MRevE		Manufactured	No			100	Each	0.0000	1.0000			
 B 58923  27 10-08-10												
SPACEPOD DOOR RH												

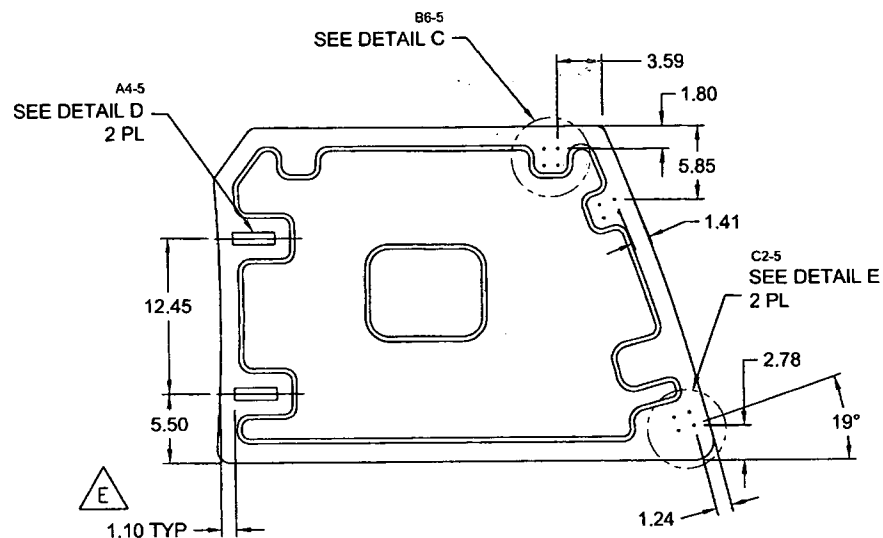


D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

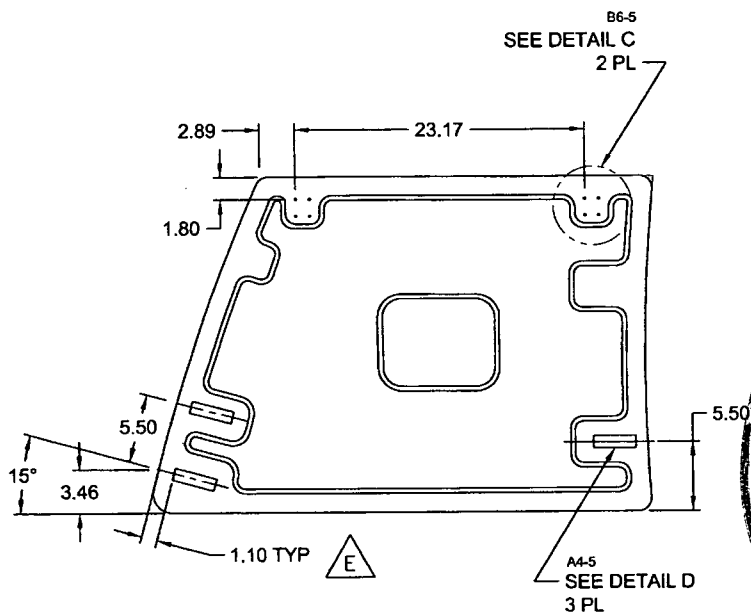
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53084
BL 09-10-22



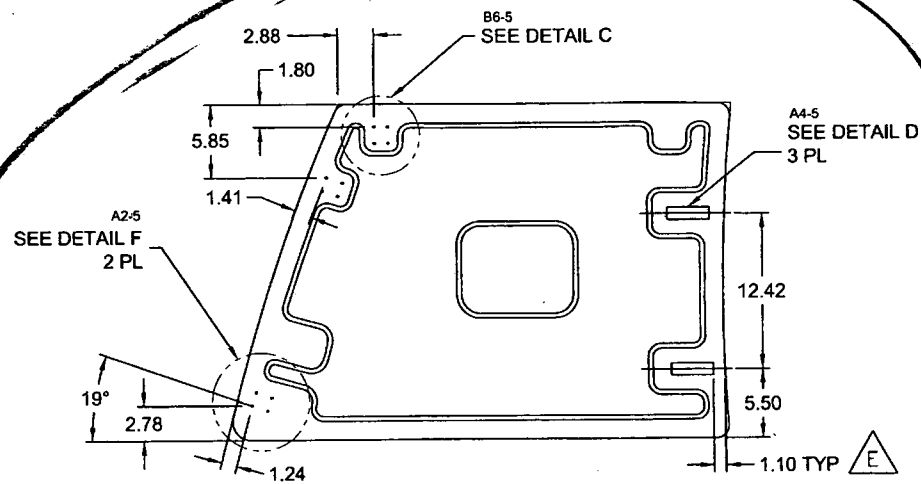
D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M-2M-3-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3186 TITLE SPACEPOD DOOR SCALE NTS REV. E SHEET 1 OF 5	
DRAWN	RF		
CHECKED	IP		
MFG. APPR.	IP		
APPROVED	IP		
DE APPR.	IP		
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D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

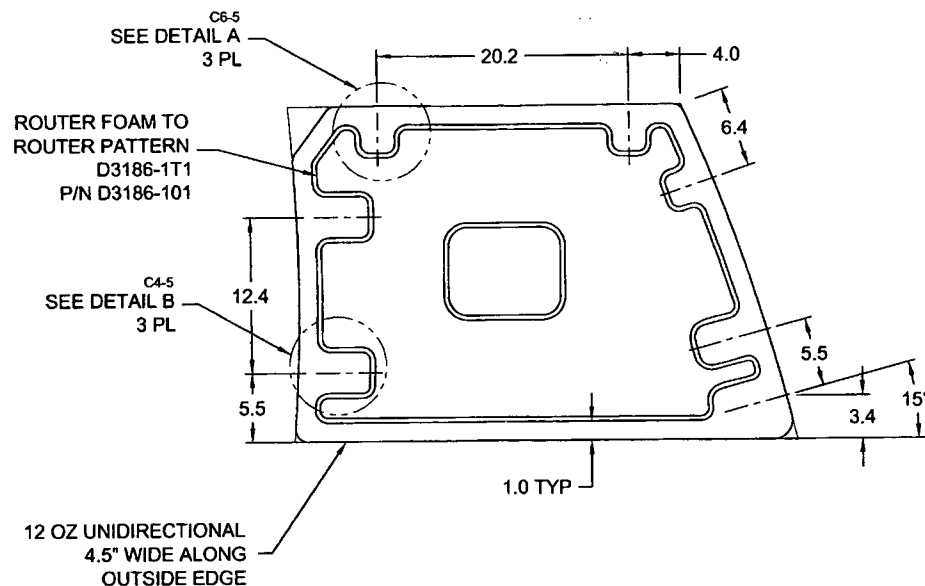
RELEASED
2008-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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53086

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:****1) MATERIAL:**

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S**3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED****4) UNITS: INCHES UNLESS OTHERWISE NOTED****5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX****6) IDENTIFICATION: NONE****7) WEIGHT: 7.0 lbs****8) USE MOLD DT8005 FOR DOOR LAYUP****MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)

9 OZ SATIN (9 SQ FEET)

FOAM

9 OZ SATIN (9 SQ FEET)

12 OZ UNIDIRECTIONAL

9 OZ SATIN (9 SQ FEET)

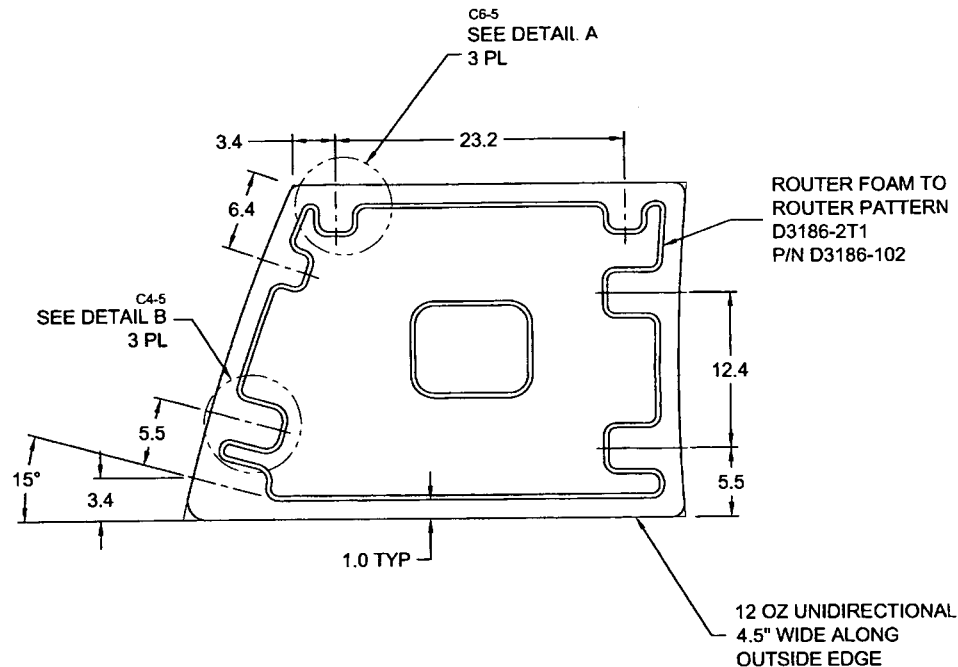
RESIN (35-45% BY WEIGHT)

PEEL PLY

RELEASED
 2009-08-08

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MFG. APPR.	UP	D3186	SHEET 3 OF 5
APPROVED	UP	TITLE	SCALE
DE APPR.	UP	SPACEPOD DOOR	NTS
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9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY







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2009-08-09

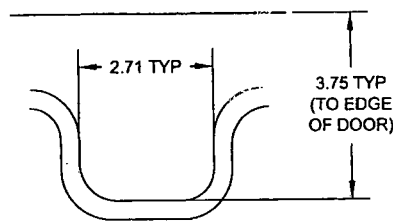
1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
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LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

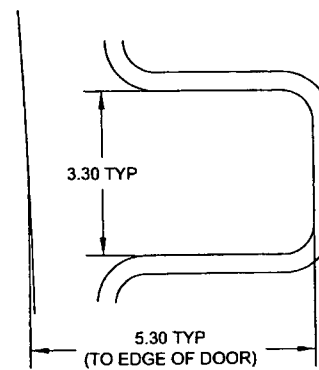
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

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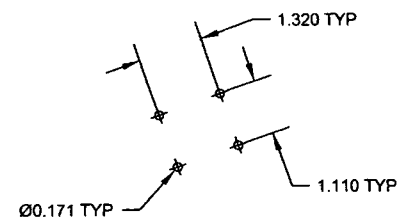
53086



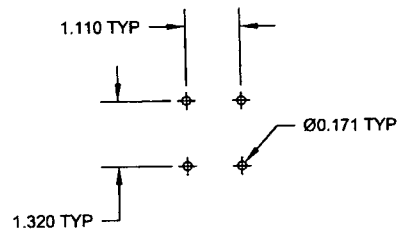
DETAIL A D6-3
SCALE 4X D4-4



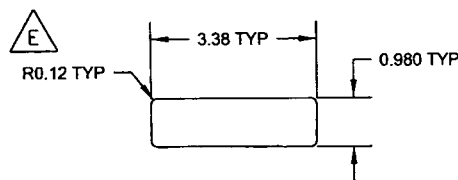
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

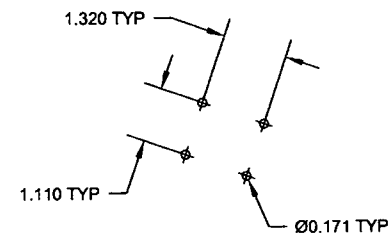


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2






NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

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2009-09-09

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MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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